

# Work Order ID 86701

\*86701\*

Page 1

July-06-12 11:36:46 AM

Item ID: D3016-13

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bracket

Start Date: 7/06/12 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-9

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3016

Rev A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3016

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

6 0 Jm 12-7-21

6 0 Jm 12-7-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86701

July-06-12 11:36:46 AM

**\*86701\***

Page 2

Item ID: D3016-13 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket  
 Start Date: 7/06/12 Start Qty: 6.00 **\*6\*** Cust Item ID:  
 Required Date: 8/03/12 Req'd Qty: 6.00 **\*6\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 Smb 12.9.21				6			
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo Form D3016-13 as per Dwg D3016	0.00 0.00				6			SB 12/09/12
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 Smb 12.9.21				6			DAS 16 12/09/12

W/O:		WORK ORDER CHANGES					
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**Work Order ID 86701**

July-06-12 11:36:46 AM

**\*86701\***

Page 3

Item ID: D3016-13

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 7/06/12

Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

0.00

**\*150\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and bag with light oil (Vactra oil #2), then \*\*\*\*\*STOCK IN LARGE

FAB\*\*\*\*\*

Location: 1WA01/24/27 (6)

160

0.00

**\*160\***

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

ML5 12-09-27ML5 12-09-27

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**NOTE:** Date & initial all entries

# Picklist Print

July-06-12 11:36:46 AM

Page 1

Work Order ID: 86701

Parent Item: D3016-13

Start Date: 7/06/12

Required Date: 8/03/12

Parent Item Name: Bracket

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B03.05.09ReformatKJ/RF  
IPP Rev:C Now On Waterjet 07-10-23 JLM Verified BY: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NS.049 4130 Sheet .049		Purchased	No			100	sf	3.8000	0.243	<del>1.5347</del> 368 1.6			

Jm 12-8-21

Location

Loc Qty

Loc Code

MAT020

3.8

11612

3.8

123049

123049

W/O:		WORK ORDER CHANGES					
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**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

**NOTES**

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO:  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86701

*RD 1207-9*

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**Dart Aerospace Ltd**

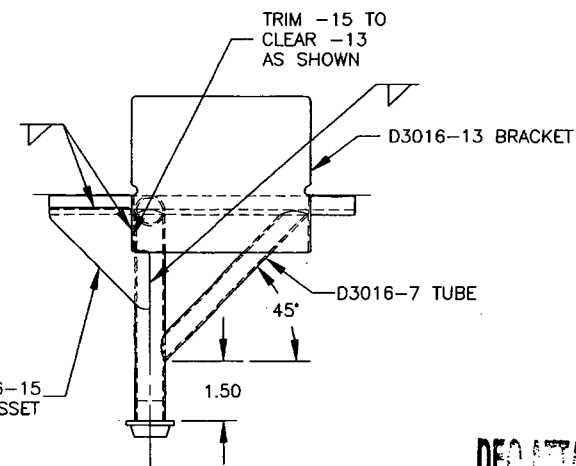
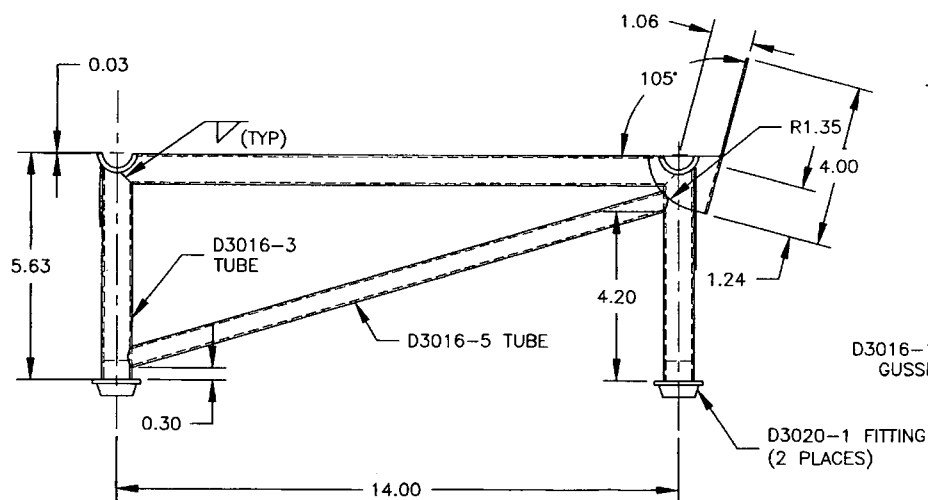
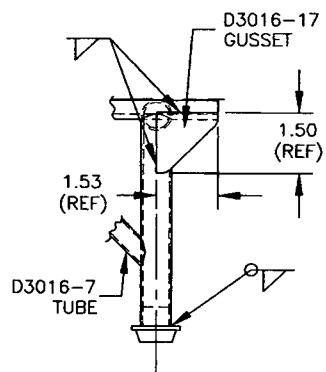
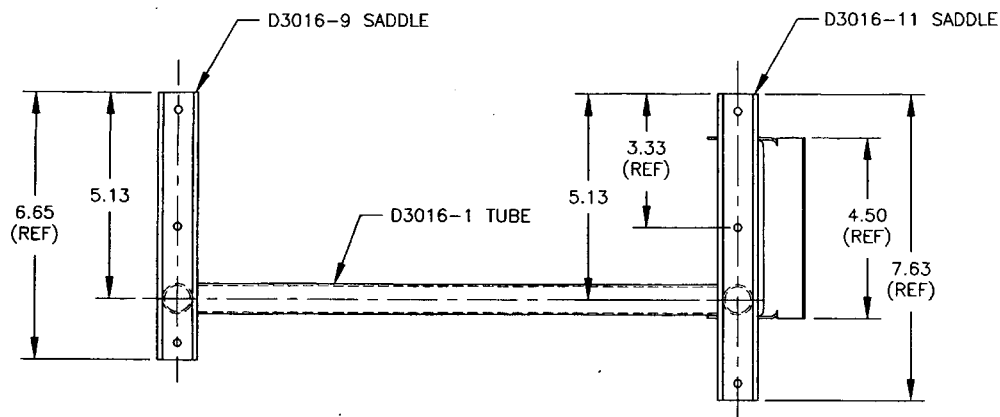
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

86701



DEB ATTACHED

RELEASE  
01.05.30

DESIGN	DRAWN BY
--------	----------

**DART**

**DART AEROSPACE LTD.**  
HARRISBURG, ONTARIO, CANADA

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CHECKED 

APPROVED 

DRAWING NO.	D3016
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REV. A  
SHEET 2 OF 3

DATE  
01.05.18

TITLE
SEAT FRAME ASSEMBLY

**SCALE**  
1:3

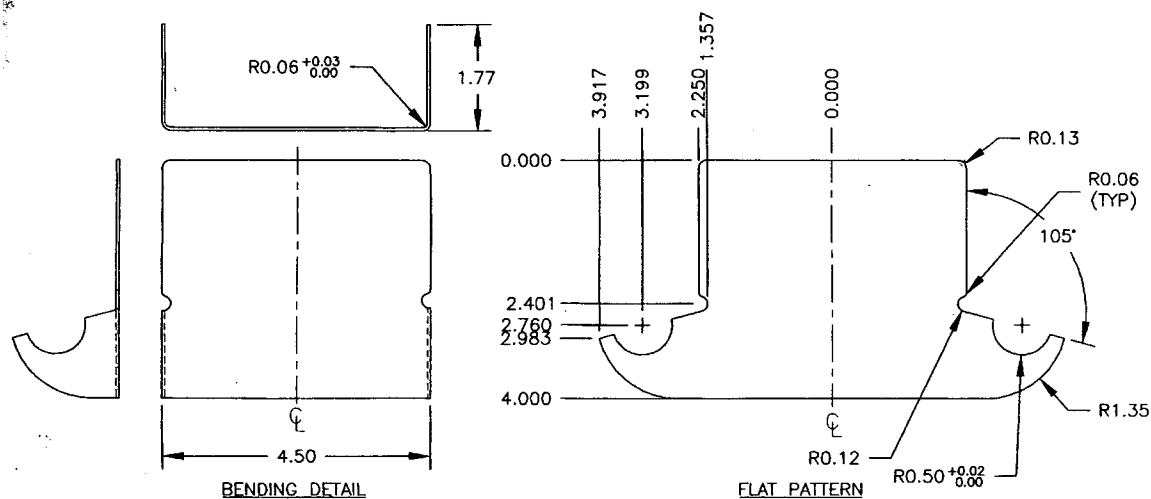
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

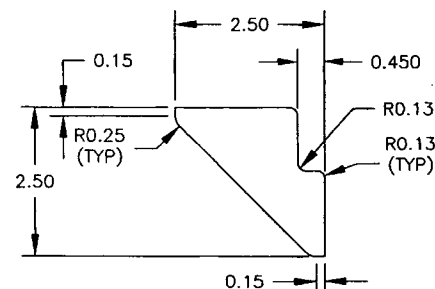
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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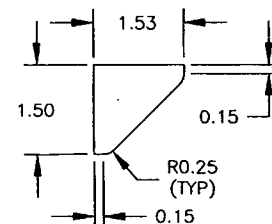
**NOTE:** Date & initial all entries



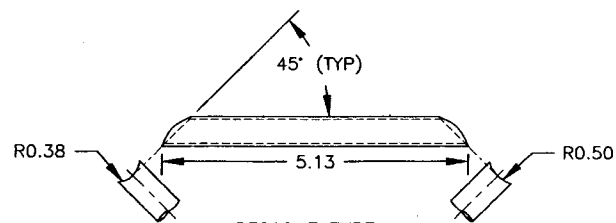
D3016-13 BRACKET



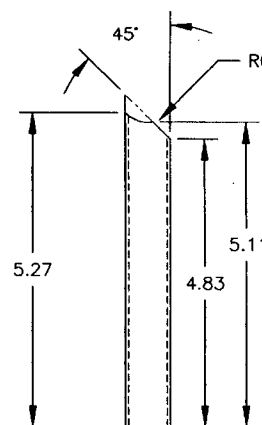
D3016-15 GUSSET



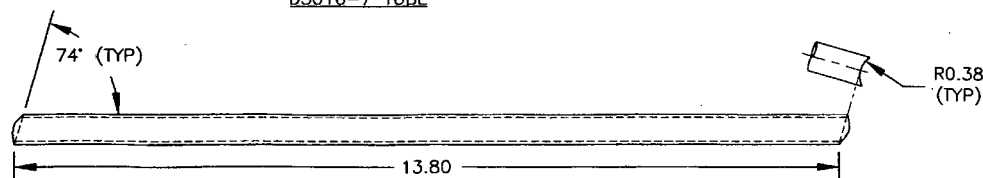
D3016-17 GUSSET



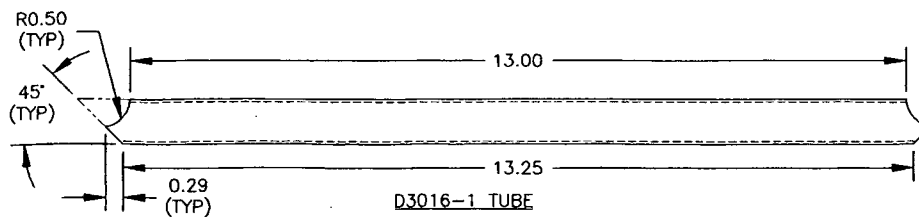
D3016-7 TUBE



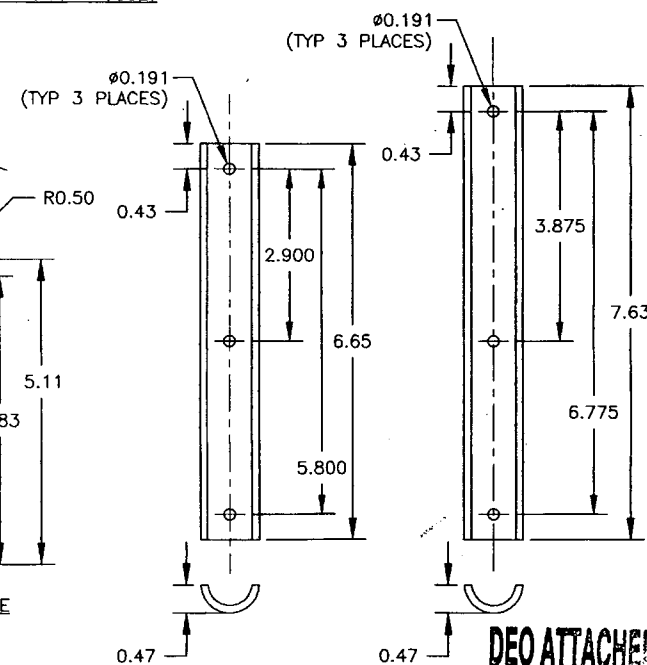
D3016-3 TUBE



D3016-5 TUBE



D3016-1 TUBE



D3016-9 SADDLE

D3016-11 SADDLE

DEO ATTACHED  
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DESIGN	CP	DRAWN BY	CP	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO.	D3016
DATE	01.05.18	TITLE	SEAT FRAME ASSEMBLY	REV. A	SHEET 3 OF 3
				SCALE	1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>UP</i>	MFG. APPR. <i>RE</i>	APPROVED <i>MAP</i>		DE APPR. <i>TH</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		DATE 10.01.29		

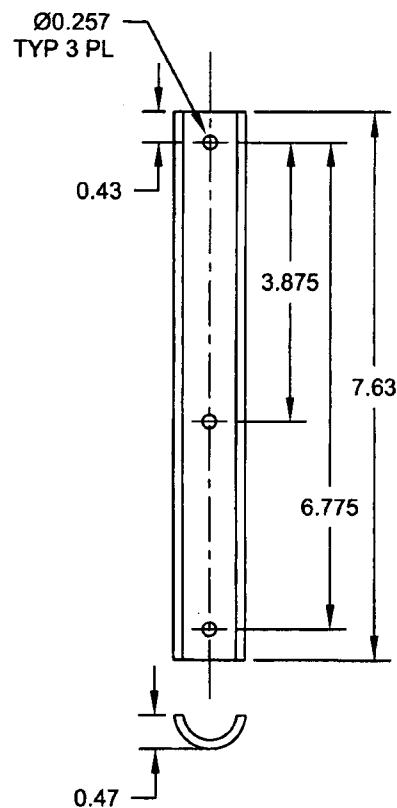
**PURPOSE:**

TO REVISE D3016-11 SADDLE'S HOLE SIZES

**CHANGE:**

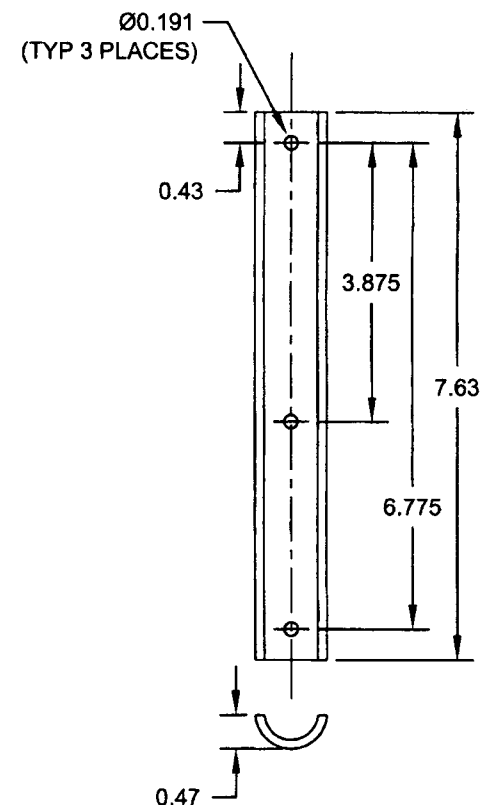
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

**IS:**



**D3016-11 SADDLE**

**WAS:**



**D3016-11 SADDLE**

W/O:		WORK ORDER CHANGES					
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